




# Work Order ID 67304


Tuesday, March 15, 2011 8:20:20 AM



## PRELIMINARY ISSUE

Page 1



Item ID: D4372-041 Accept  Setup Start   
 Revision ID: PRELIM Stop   
 Item Name: Retainer Assembly

Start Date: 3/15/2011 Start Qty: 2.00   
 Required Date: 3/17/2011 Req'd Qty: 2.00   
 Cust Item ID:  
 Customer:

Reference: *Jul 11-03-15*




Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_


Run Start   
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr
D4372	PA1

100		0.00							
									
Mill Conv	Memo	0.00							
Conventional Milling Machine	MILL AS PER DWG								

*Jul 11-03-15* 2 0

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

*Jul 11-03-15* 2 0

120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

*B.A. 11/03/15* 2 0

**Work Order ID 67304**

Tuesday, March 15, 2011 8:20:20 AM

Page 2

Item ID: D4372-041

Accept

Revision ID: PRELIM

Item Name: Retainer Assembly

Start Date: 3/15/2011 Start Qty: 2.00

Required Date: 3/17/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Small Fab

Memo

c'sink as per dwg

0.00

0.00

ES 11/03/16 (2)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Q12

11-03-16

PA2

0.00

0.00

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

2 0 11/03/16

**Work Order ID 67304**

Tuesday, March 15, 2011 8:20:20 AM

Page 3

Item ID: D4372-041

Accept

Revision ID: PRELIM

Item Name: Retainer Assembly

Setup Start

Stop

Start Date: 3/15/2011 Start Qty: 2.00

Required Date: 3/17/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-3-16

170



Small Fab

Memo

0.00

Small Fab

INSTALL NUTPLATES AS PER DWG

180



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00






N/A  
11.03.15

**Work Order ID 67304**



Tuesday, March 15, 2011 8:20:20 AM





Page 4

Item ID: D4372-041 Accept  Setup Start   
Revision ID: PRELIM Stop   
Item Name: Retainer Assembly  
Start Date: 3/15/2011 Start Qty: 2.00  Cust Item ID:  
Required Date: 3/17/2011 Req'd Qty: 2.00  Customer:

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  Packaging Packaging	Identify as per dwg & Stock Location: <i>Red Shelf</i>  Memo	0.00  0.00				2	0		
200  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*ship to Harvey at Eagle.*

*RD1370mar*

**POSITIVE RECALL**  
EFFECTIVE 11-03-15 AUTH W  
RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

# Picklist Print

Tuesday, March 15, 2011 8:20:16 AM

Page 1

Work Order ID: 67304

Parent Item: D4372-041

Parent Item Name: Retainer Assembly

Start Date: 3/15/2011

Required Date: 3/17/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-03-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X05.00 0		Purchased	No				f	41.7636		0.612632			



6061-T6 Bar .500 x 5.00



Location

Loc Qty

Loc Code

MAT03

41.7636

112041

18.9

112154

22.8636

Each

5,975.000

MS20426AD3-7

Purchased

No



RIVET

Location

Loc Qty

Loc Code

ST316

5975

17694

5975

Each

299.0000

MS21059L08

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST301

299

112314

200

12706

99

*Handwritten signature*  
11-03-15  
12

*Handwritten signature*  
6  
3/15/03/16  
6

DART AEROSPACE LTD		Work Order: 67304
Description: <i>Returned</i>		Part Number: D4372-1
Inspection Dwg: 4372	Rev: PA1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

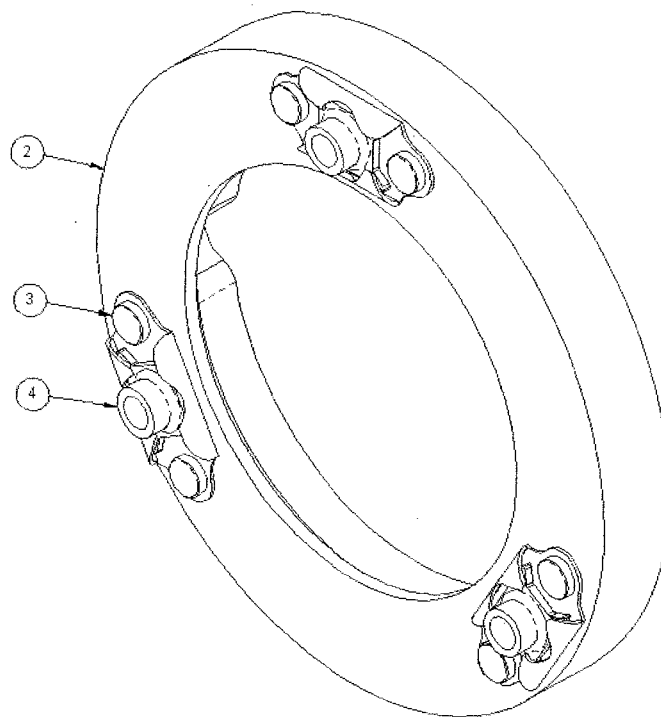
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.10	2.997	✓		SLM V6	
<del>2.593</del>	<del>+/-0.10</del>	N/A				
2.500	+/-0.10					
1.960	+/-0.10	1.960	✓			
R.150	+/-0.10	R.150	✓			
2.160	+/-0.10	2.161	✓			
Ø.173	+0.004/-0.004	Ø.173	✓			
Ø.098	+0.004/-0.004	.101	✓			
.344	+/-0.005	.343	✓			
.688	+/-0.005	.687	✓			
.375	+/-0.10	.374	✓			
.260	+/-0.10	.257	✓			
.065	+/-0.10	.075	✓			
.050x45	+/-0.10	.049x45	✓			

Measured by: <i>[Signature]</i>	Audited by: H.A	Preliminary Approval:
Date: 11/03/15	Date: 11/03/15	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*[Signature]* 10.04.15

ITEM NO.	QTY. 041	PART NUMBER	DESCRIPTION
1	X	D4372-041	RETAINER ASSEMBLY
2	1	D4372-1	RETAINER
3	6	MS20426AD3-7	RIVET
4	3	MS21059L08	ANCHOR NUT (OR MS21060L08)



w/ 67304

**PRELIMINARY ISSUE**

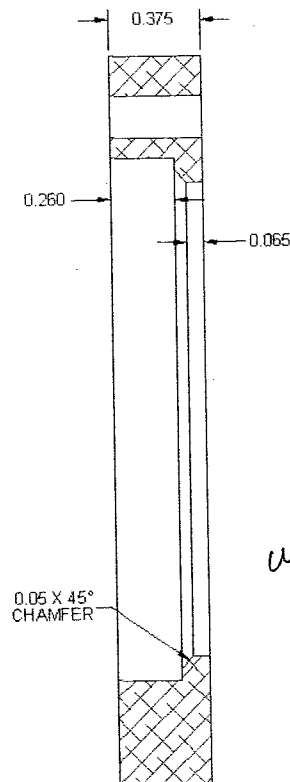
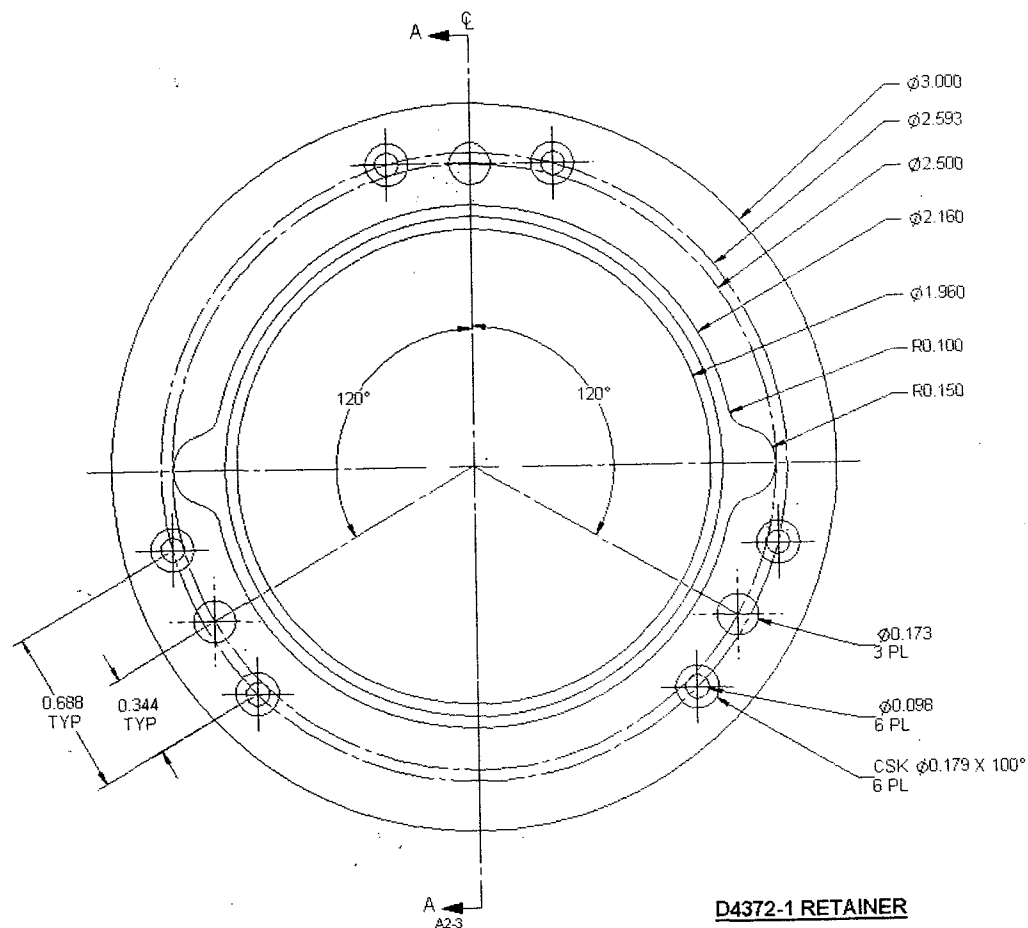
11.03.14

**D4372-041 RETAINER ASSEMBLY**

**NOTES**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAMKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4372</b>	SHEET 2 OF 3
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	<b>RETAINER</b>	NTS
DATE	<b>11.03.14</b>	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



*w/o 67307*

**SECTION A-A**  
**SCALE 2X** A5-3

**D4372-1 RETAINER**

**PRELIMINARY ISSUE**

11.03.14

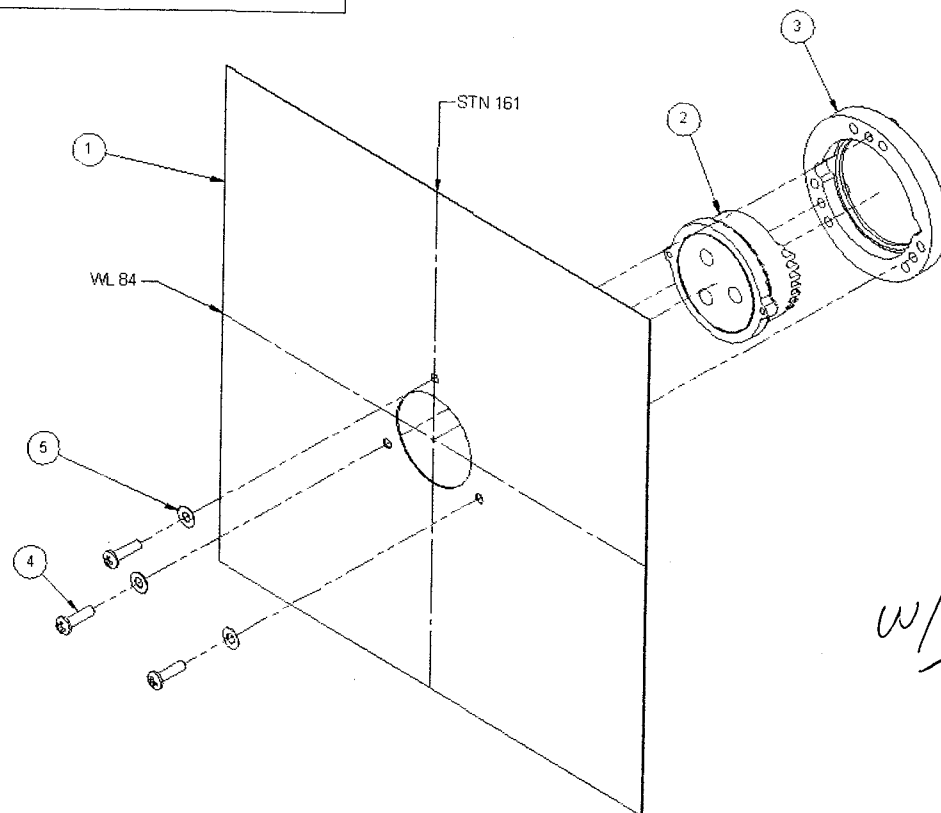
**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM BAR  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI005 4.1
- 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.12 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4372</b>	REV. PA1
MFG. APPR.			SHEET 3 OF 3
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	<b>RETAINER</b>	NTS
DATE	<b>11.03.14</b>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT &amp; ITS CONTENTS ARE UNCLASSIFIED IN THE EXCESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIES OR COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	-	FUSELAGE
2	1	01-0771186-01	DISC LIGHT
3	1	D4372-041	RETAINER ASSEMBLY
4	3	MS35207-246	SCREW
5	3	NAS1149DN816J	WASHER



# **DISC LIGHT INSTALLATION**

**PRELIMINARY ISSUE**

11.03.14

## **NOTES:**

- 1) DRILL  $\varnothing 0.175$  HOLE AT LOCATION SHOWN
- 2) POSITION RETAINER CENTERED OVER HOLE
- 3) TRANSFER 3X  $\varnothing 0.173$  HOLES FROM RETAINER TO AIRCRAFT SKIN
- 4) DEBURR HOLES

PA1	NEW ISSUE		11.03.14
REV.		DESCRIPTION	BY DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED	N/A		
DE APPR.	N/A		
DATE	11.03.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4372**

TITLE  
**RETAINER**

REV. PA1  
SHEET 1 OF 3

SCALE  
NTS

COPYRIGHT © 2011 BY DART AEROSPACE LTD  
THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE USED FOR ANY PURPOSE OF COMMERCE OR OTHER PERSON WITHOUT  
WRITTEN PERMISSION FROM DART AEROSPACE LTD.